

Work Order ID 68503

Thursday, April 14, 2011 10:20:07 AM



Page 1

Item ID: D3213-041

Accept



Setup Start



Revision ID:

Item Name: Door Assembly

Stop



Start Date: 4/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/04/11

Tooling: Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3213	Rev A

100



Small Fab

Small Fab

Memo 0.00

Small Fab

1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520

EB 11/05/10 ⑥

Identify as D3213-041

110



QC5- Inspect part completeness to step on W/O

QC

Quality Control

0.00

*S ual 10**86*

120



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Powdercoat

Powder Coating

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*320° 1:00 1:30**M115128**6 11/05/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68503

Thursday, April 14, 2011 10:20:08 AM



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Item ID: D3213-041

Accept



Setup Start



Revision ID:

Item Name: Door Assembly

Stop



Start Date: 4/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Assemble as per Dwg D3213

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68503

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Thursday, April 14, 2011 10:20:08 AM

Item ID: D3213-041

Accept



Setup Start



Revision ID:

Item Name: Door Assembly

Stop



Start Date: 4/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionIdentify as per dwg & Stock Location 211Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Packaging

Packaging

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF

11-05-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:20:00 AM

Page 1

Work Order ID: 68503



Parent Item: D3213-041



Parent Item Name: Door Assembly

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-3		Manufactured	No			100	Each	6.0000	2	12	<i>E511/05/10</i>	<i>B68895 (2)</i>	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
					ST037			6					
					66038			6					
D3213-1		Manufactured	No			100	Each	2.0000	1	6	<i>E511/05/10</i>	<i>B68906 (4)</i>	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
					ST232B			2					
					65142			2					
D3213-3		Manufactured	No			100	Each	4.0000	1	6	<i>E511/05/10</i>	<i>B68907 (2)</i>	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
					ST232B			4					
					65143			4					
MS20470AD4-6		Purchased	No			100	Each	3,914.000	1	6	<i>E511/05/10</i>	<i>B68907 (2)</i>	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
					ST319			3914					
					116391			884					
					117395			3030					
										6			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:20:00 AM

Page 2

Work Order ID: 68503



Parent Item: D3213-041



Parent Item Name: Door Assembly

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 6.00

Required Qty: 6.00

AN960JD6



NAS1149DN632J Purchased

No

140

Each

175.0000

1

6

Washer

40



EBSu/05/10
M116978 (6x)

D2137



Manufactured

No

140

Each

11.0000



1

6
EBSu/05/11

Decal - No Step

Location

Loc Qty

Loc Code

ST347

175

104537

175

140

Each

11.0000



1

5
1

D2419



Manufactured

No

140

Each

1.0000



1

6
EBSu/05/11
B68896 (5x)

Handle

Location

Loc Qty

Loc Code

GA

11

62071

10

65121

1

140

Each

1.0000



1

14.4
EBSu/05/11

D2462



Manufactured

No

140

f

480.0000



2.4

14.4
EBSu/05/11

Seal

Location

Loc Qty

Loc Code

GA

1

63423

1

140

f

480.0000



0

0
EBSu/05/11

D2728-1



Manufactured

No

140

Each

0.0000



0

0
EBSu/05/11

Dart Logo label

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Thursday, April 14, 2011 10:20:01 AM

Page 3

Work Order ID: 68503



Parent Item: D3213-041



Parent Item Name: Door Assembly

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-4

Purchased

No

140

Each

2,678.000

24

144



Rivet, Universal Head



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	2678	
116188	2317	
116391	361	

EP 11/05/10
144

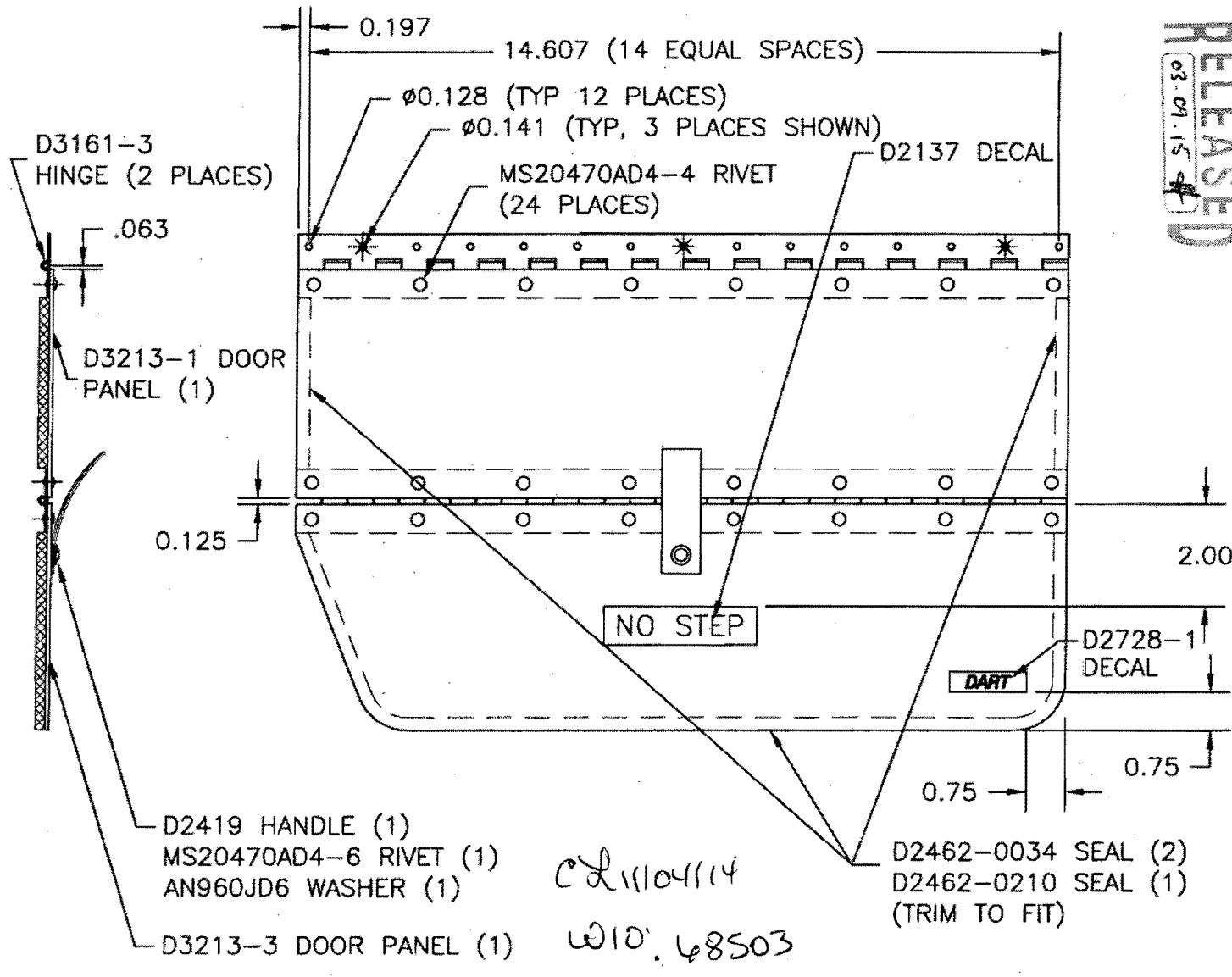
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03-09-15

DART

©ACOPY
DRAFT

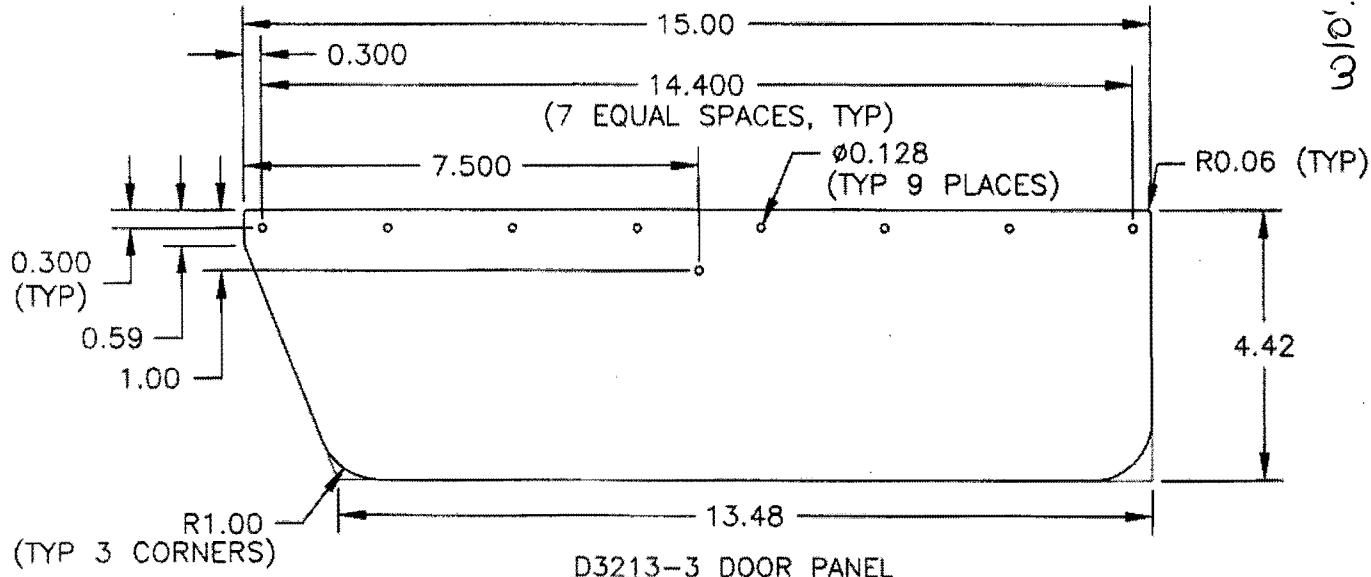
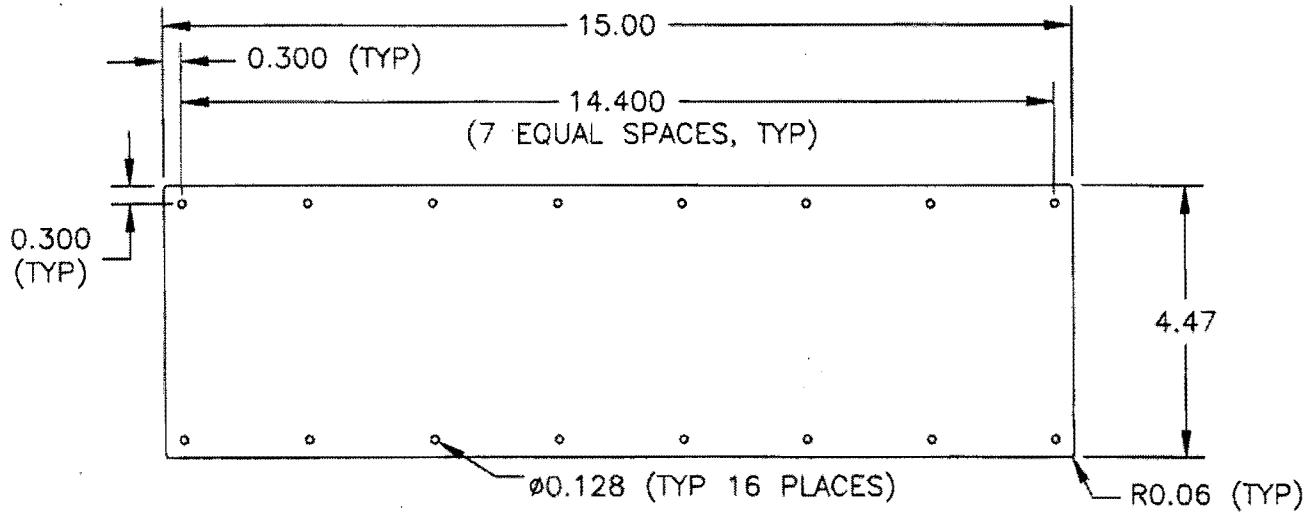
DESIGN	DRAWN BY	DART AEROSPACE LTD
C	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3213
DATE		TITLE
03.09.03	03.09.03	DOOR ASSEMBLY
		NEW ISSUE

REV. A
1 OF 2
SCALE
1:3





DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3213
DATE		REV. A
03.09.03		2 OF 2
		SCALE
		1:3



D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03

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